

CLAIM 1. Procedure for attaching a headrest-tube to an elongate seatframe-piece of an automobile seat, including:

- providing the seatframe-piece in a configuration comprising a web, having an upper side and a lower side;
- providing a through-hole in the web of the seatframe-piece, the headrest-tube being a clearance fit in the through-hole;
- making a sub-assembly by placing the headrest-tube in the through-hole in the top-rail;
- providing a die-set, and arranging the sub-assembly in the die-set;
- providing the headrest-tube with a first shoulder, which lies in contact with a first side of the web of the seatframe-piece over an annular margin of the first side of the web surrounding the through-hole;
- pressing the headrest tube axially, in the die-set, in such manner as to expand the headrest-tube diametrically, at least over a region of the headrest-tube adjacent to the other side of the web, thereby forming a second shoulder of the headrest-tube; wherein the second shoulder lies in contact with the other side of the web of the seatframe-piece, over an annular margin of the other side of the web, surrounding the through-hole;
- pressing the axially on the first and second shoulders, with sufficient force to coin the first and second shoulders together, onto the two sides of the web;
- taking the sub-assembly out of the die-set, leaving the web of the seatframe-piece gripped between the first and second shoulders of the headrest-tube.